IN THE CLAIMS

Please amend the claims as follows:

1. (Currently Amended) A method comprising
    a) providing a multi-layer bonded non-woven composite elastic material under tension;
    b) heating the composite elastic material;
    c) retracting the heated composite elastic material; and
    d) cooling the composite elastic material.

2. (Original) The method according to claim 1, wherein heating comprises heating the material by drawing heated air through the composite elastic material.

3. (Original) The method according to claim 1, wherein heating comprises heating the material to the softening point of the elastic layer.

4. (Original) The method according to claim 1, wherein retracting comprises retracting the material from about 2 % to about 15 %.

5. (Original) The method according to claim 1, wherein retracting comprises retracting the material from about 4 % to about 10 %.

6. (Original) The method according to claim 1, wherein heating comprises heating the composite elastic material on a first roller and cooling the material on a subsequent roller.

7. (Original) The method according to claim 1, wherein the composite elastic material is heated on a first roller, on a second roller, and cooling the material on a subsequent roller.

8. (Original) The method according to claim 6, wherein the speed of the material on the subsequent roller is about 2 % to about 15 % slower than the speed of the first roller.

9. (Original) The method according to claim 8, wherein the speed of the material on the subsequent roller is about 4 % to about 10 % slower than the speed of the material on the first roller.

10. (Original) The method according to claim 7, wherein the speed of the material on the subsequent roller is from about 2 % to about 15 % slower than the speed of the material on the second roller.

11. (Original) The method according to claim 10, wherein the speed of the material on the subsequent roller is from about 4 % to about 10 % slower than the speed of the material on the second roller.

12. (Original) The method according to claim 9, wherein heated air is drawn through the first roller and the second roller.

13. (Original) The method according to claim 9, wherein cool air is drawn through the subsequent roller.

14. (Original) The method according to claim 1, wherein the composite elastic material has a density less than about 0.085 g per cubic cm and has a CD tensile strength of greater than about 0.68 pounds.

15. (Original) The method according to claim 1, wherein the composite elastic material has a cup crush less than about 120 g per cm and a CD tensile strength of greater than about 0.68 pounds.

16. (Previously Presented) The method according to claim 1, wherein the composite material has a cup crush to density ratio of less than about 1579 cm^4 and greater than about 950 cm^4.

17. (Currently Amended) The method according to claim ~~1~~ 6, wherein cooling includes cooling the composite material at on the subsequent roller, and ~~then~~ further comprises cooling on ~~the~~ a winder roll.

18. (Currently Amended) The method according to claim 17, wherein cooling includes cooling the composite material to a first temperature on the subsequent roller and then cooled to a second temperature on the winder roll.

19. (Original) The method according to claim 18, wherein the first temperature is greater than the second temperature.

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49. (New) A method comprising

a) providing a non-woven composite elastic material under tension;

b) heating the composite elastic material;

c) retracting the heated composite elastic material; and

d) cooling the composite elastic material;

wherein heating comprises heating the material by drawing heated air through the composite elastic material.

50. (New) The method of claim 49 wherein heating comprises heating the material to the softening point of the elastic layer.

51. (New) The method of claim 49 wherein retracting comprises retracting the material from about 2 % to about 15 %.

52. (New) The method of claim 49 wherein retracting comprises retracting the material from about 4 % to about 10 %.

53. (New) The method of claim 49 wherein heating comprises heating the composite elastic material on a first roller and cooling the material on a subsequent roller.

54. (New) The method of claim 49 wherein the composite elastic material is heated on a first roller, on a second roller, and cooling the material on a subsequent roller.

55. (New) The method of claim 53 wherein the speed of the material on the subsequent roller is about 2 % to about 15 % slower than the speed of the first roller.

56. (New) The method of claim 55 wherein the speed of the material on the subsequent roller is about 4 % to about 10 % slower than the speed of the material on the first roller.

57. (New) The method of claim 54 wherein the speed of the material on the subsequent roller is from about 2 % to about 15 % slower than the speed of the material on the second roller.

58. (New) The method of claim 57 wherein the speed of the material on the subsequent roller is from about 4 % to about 10 % slower than the speed of the material on the second roller.

59. (New) The method of claim 56 wherein the heated air is drawn through the first roller and the second roller.

60. (New) The method of claim 56 wherein the cool air is drawn through the subsequent roller.

61. (New) The method of claim 49 wherein the composite elastic material has a density less than about 0.085 g per cubic cm and has a CD tensile strength of greater than about 0.68 pounds.

62. (New) The method of claim 49 wherein the composite elastic material has a cup crush less than about 120 g per cm and a CD tensile strength of greater than about 0.68 pounds.

63. (New) The method of claim 49 wherein the composite material has a cup crush to density ratio of less than about 1579 cm^4 and greater than about 950 cm^4.

64. (New) The method of claim 53 wherein cooling includes cooling the composite material at on the subsequent roller, and further comprises cooling on a winder roll.

65. (New) The method of claim 64 wherein cooling includes cooling the composite material to a first temperature on a subsequent roller and then cooled to a second temperature on the winder roll.

66. (New) The method of claim 65 wherein the first temperature is greater than the second temperature.

67. (New) A process for preparing a multi-layer bonded non-woven composite elastic material comprising

a non-woven elastic layer;

two non-woven gatherable layers;

wherein the elastic layer is positioned between the gatherable layers;

comprising the steps of

bonding the gatherable and elastic layers at least at two points;
providing the composite elastic material under tension;
heating the composite elastic material;
retracting the heated composite elastic material; and
cooling the composite elastic material.

68. (New) The process according to claim 67 wherein heating comprises drawing a heated air through the composite elastic material.

69. (New) The process according to claim 68 wherein heating comprises heating the material to the softening point of the elastic layer.

70. (New) The process according to claim 67 wherein heating comprises heating the composite elastic material on a first roller and cooling the material on a subsequent roller.

71. (New) The process according to claim 67 wherein the composite elastic material is heated on a first roller, on a second roller, and cooling the material on a subsequent roller.

72. (New) The process according to claim 67 wherein heating comprises heating on a first roller and optionally a second roller and cooling on a third roller and wherein retraction of the bonded composite elastic material is controlled by adjusting the speed of the rollers.